

Work Order ID 73415

Wednesday, August 31, 2011 3:08:49 PM



Page 1

Item ID: D2947

Accept



Setup Start



Revision ID:

Item Name: Clamp

Stop



Start Date: 9/1/2011 Start Qty: 100.00



Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 100.00



Customer:

Reference:

Approvals: Process Plan: CL Date: 11/09/01

Tooling:

Date:

Run Start



QC: Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2947	Rev A1								
100	PURCHASING	0.00							
	Waterjet								
	FLOW CNC Waterjet								
	304 .063								
	Memo	0.00							
	1-Cut as per Dwg								
	Dwg Rev: <u>A1</u>								
	Prog Rev: <u>A1</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
	Quality Control								
	Memo	0.00							

B11-9-12

109

B11-9-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item Name: Clamp					
Start Date: 9/1/2011	Start Qty: 100.00		Cust Item ID:		
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Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				count 109			
						QSP019			
130 Brake NC Brake NC	Bend as per dwg Small Fab Memo	0.00 0.00				109			
						SP up 10/03			
150 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				count 109			
						QSP013			

W/O:		WORK ORDER CHANGES					
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Accept



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Revision ID:

Stop



Item Name: Clamp

Start Date: 9/1/2011 Start Qty: 100.00



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Required Date: 9/16/2011 Req'd Qty: 100.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location	0.00							
Packaging	Memo	0.00							
Packaging									
170	QC21 - Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

SP 11-10-5

11/10/6

ME 11-10-6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 73415

Parent Item: D2947

Parent Item Name: Clamp



Start Date: 9/1/2011

Required Date: 9/16/2011

Start Qty: 100.00

Required Qty: 100.00



Comments:

IPP: A□00.01.14□New issue□EC□

IPP Rev:B No longer made in house 07-06-11 JLM

IPP REV:C

11.08.08. MADE IN HOUSE DD VERF :EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 		Purchased	No			100	sf	129.1000	0.062	6.526316	6.8		
304/316 Sheet .063											1311-9-12		

Location

Loc Qty

Loc Code

MAT020

116.5

118578

116.5

MAT021

12.6

118217

12.6

118578

(109)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

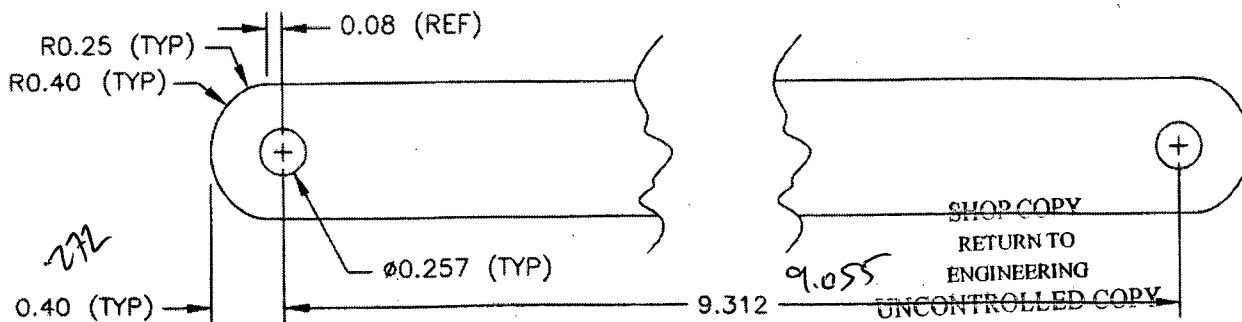
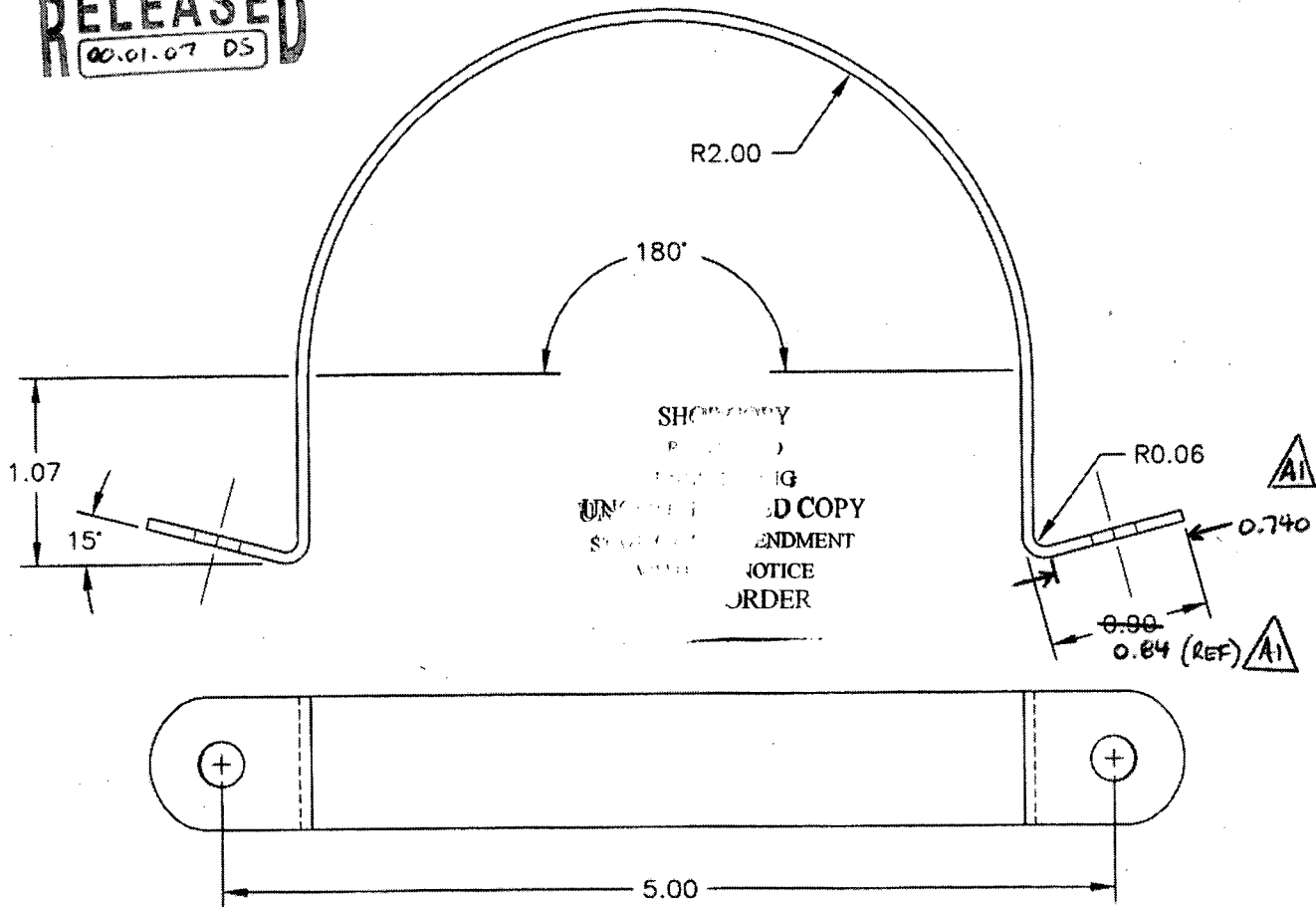
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DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2947	REV. A SHEET 1 OF 1
DATE 00.01.06	TITLE CLAMP		SCALE 1:1
A	00.01.06	NEW ISSUE	

RELEASED
00.01.07 DS



D2947 FLAT PATTERN

MATERIAL: AISI 304/316 SS 0.063 THICK x 0.75 WIDE
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

73415
CL 11/09/01

01.09.07 Add 0.740 dimension; 0.84 L&S 0.90
A1